



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2057

Job Sheet 168313



Part No: D2057

Job Qty: 10 ea

Part Name: Plug



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/13/17

Job Tracking No:

Due Date: 11/16/17

Created By: Linda Lacelle

Type: Stock

Description:

Customer: Agustawestland Philadelphia Corp (CAGUS02)

3050 Red Lion Road Philadelphia, PA, 19114 USA ph:(215) 281-1400 fx:(215) 281-0447.

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign off
					Setup hrs	Run Hrs	Workcenter / Supplier			
90	Start up Operation	10 Ea	11/15/17	11/15/17	0.00	0.00	Start Up Machining			23
100	Hardinge	10 pcs	11/16/17	11/16/17	0.00	0.58	Hardinge			9-89
120	QC	10 pcs	11/16/17	11/16/17	0.00	0.00	QC8			<i>9/18/17</i>
130	Packaging	10 pcs	11/16/17	11/16/17	0.00	0.00	Packaging3	<i>GA</i>		<i>AT 18/10/17</i>
140	QC21-SA	10 Ea	11/16/17	11/16/17	0.00	0.00	QC21			<i>CMZ</i>

Part Op **100** - Make as per Dwg D2057 and Folio FA260. Break all sharp edges 0.015 max. Do not drill Ø0.191
Descriptions: **130** - LOCATION : GA

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6R0.750	1	36	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Plug	1.150Inches ± 0.030	1.180 1.120		
2	Plug	0.150Inches ± 0.030	0.180 0.120		
3	Plug	0.750Inches ± 0.030	0.780 0.720		
4	Plug	0.030Inches ± 0.030	0.060 0.000		
5	Plug	45.000Degrees ± 0.000	45.000 45.000	Angle	
6	Plug	0.397Inches + 0.005 - 0.000	0.402 0.397		
7	Plug	0.150Inches ± 0.030	0.180 0.120	Radius	

Plex 11/14/17 8:04 AM dart.boucher.sylvie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order: _____	Suspect
Part No. _____	
NCR No. _____	

Date : _____	Step #: _____
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Description Work Order Deviation



Plug

Dart Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL.: 1 613 632-5280
 Email: sales@dartaero.com
 www.dartaerospace.com

neering	☐
Quality	☐
Other	☐

042) Approval

Deleted By

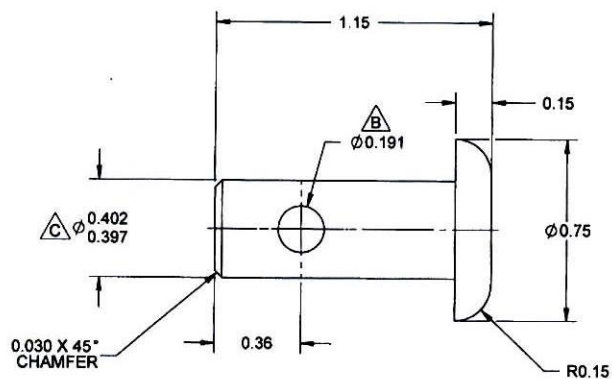
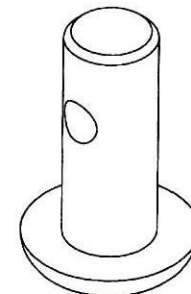
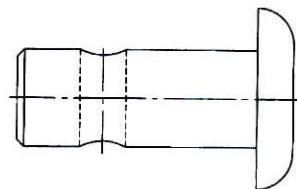
/ Supervisor
Verification

Coordinator
approval

PART NO: D2057
Revision:
Operation: Start up Operation
Change No:

Mfg Date: 01/10/18
Job No: 168313

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐								
Misidentified	☐	Past Due	☐	OTHER :							



D2057 PLUG

RELEASED
08.06.10

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF DART SPEC M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

REV.	DESCRIPTION	BY	DATE
C	Ø 0.402/Ø 0.397 WAS Ø 0.430/Ø 0.425; REASON: ID OF D2010-103/-104 DECREASED TO Ø 0.402	PH	08.06.10
B	REDRAWN: Ø 0.191 WAS Ø 0.187 (TSR A1100)	CP	98.10.15
A	NEW ISSUE	JB	92.03.13
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JB		
CHECKED	JB	DRAWING NO.	REV. C
MFG. APPR.	JB	D2057	SHEET 1 OF 1
APPROVED	JB	TITLE	SCALE
DE APPR.	JB	PLUG	NTS
DATE	08.06.10	COPYRIGHT © 1992 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					